

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004209**Date Inspected:** 23-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Bao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

**OBG Assembly Bay**

5AE- Welding being performed in the 3G position utilizing FCAW at SSD20A panel point 031 to LD002-031 by Dan De Yin and overseen by ZPMC QC representative Zhang Xian Ji.

5BE- Preparation operation at SSD18A panel point 34 weld 133 for welding in the 3G position. QA observed what appeared to be freehand cutting of one of the joints. Pictures are available for review if needed. QA was told by ZPMC QC representative Zhang Xian Ji that Wei Xian Qi was quoted as saying it was cut by the freehand method. QA queried QC if they plan to write a non conformance report. It appeared that QC was not sure. QA confirmed later with Mang Lu that indeed an ZPMC internal NCR would be generated for this issue.

EP039A- Base metal repair being performed without any preheating torch in the vicinity. QA was able to place the back of the hand upon weld termination in the area directly adjacent to the joined location. QA determined that the preheat requirement was 65C. ZPMC translator Testino was brought in for clarification and said that they were preheating. At which time the laborers brought a torch out and proceeded to preheat. Pictures available upon request.

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The above mentioned items as observed, corrected by contractor QC & documented by QA appear to conform to the contract documents.

### Summary of Conversations:

No relevant conversations this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Vatcher,Robert
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert
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QA Reviewer
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